rod with a clamping screw at the extreme end of the pivoted clamp, pressure is brought to bear upon the ends of the connecting-rods on each side of the pivoted clamp, thus making the clamping very rapid. At the inside end, one clamp also holds two rods in place. This clamp is provided with a small pin which fits into a slot in the clamping stud, so that, when tightened, the clamp must always be in one position and cannot come out far enough to interfere with the milling cutters.

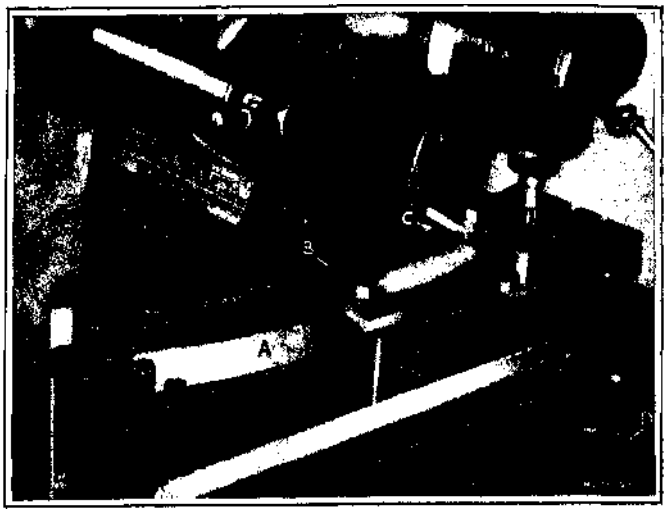

Fig. 16. Fixture for Rough-mining a Circular Slot *in* Sight-bar

Radial Milling Fixtures. Radial fixtures are so called because they are used for machining parts to a given radius. In general, the work-holding part of the fixture is either pivoted or is guided by a curved track so that it is given a circular motion when in use. Some ingenious radial fixtures used for machining the sight-bars of naval gun mounts, at the plant of the Mead-Morrison Mfg. Co., East Boston, Mass., will be described. The radial or circular surface of the sight-bar must be so nearly perfect that the sight may he operated through its complete range of adjustments without any binding action and without perceptible lost motion between the moving parts. The curved surfaces of the sight-bar and of the bearing in the sight-bar bracket must be exactly concentric with the axis